

5/12

DART AEROSPACE LTD	Work Order:	22688
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	20 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	DA	05.03.14	20																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	DA	05.03.24	20																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: - M17227	EP	05/04/17	20																																																
4	MV	Inspect material for defects or damage prior to machining	EP	05/04/12	20																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	SD	05.04.13	20																																																
6	QC2	Inspect parts as they come off the CNC machine	SD	05.04.13	20																																																
7	MV	Deburr	SD	05.04.13	20																																																
8	QC8 & 5	Second inspection	WZ	05/04/16	20																																																
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21872</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B21846/B22494</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B22688</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B21586/21189/B22503</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B21587/B22504</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B22505</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>m14544/m1532/m16067</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>m14311/m14526</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>m15993</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15924</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B21872	12	D2274	Radius Block	B21846/B22494	2	D2432F	24" Bearpaw	B22688	6	D2438	Clamp	B21586/21189/B22503	12	D2529	Washer	B21587/B22504	6	D2732-050	Rubber Cushion	B22505	12	AN4-15A	Bolt	m14544/m1532/m16067	12	AN4-17A	Bolt	m14311/m14526	24	AN960JD416	Washer	m15993	12	MS21042L4	Nut (or -4)	m15924	1	Paperwork package from Step 2					
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SD	05/04/25	20																																																
11	PK	Identify and pack for shipping as per PPP K10008 REV.E	SD	05/04/25	20																																																
12	AC	Cost / part 220.35	545	05.04.26	20																																																
13	DC	Close W/O 220.35 Inspect Level 21	DA	05.05.03	20																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22688
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
B	5.500	+/-0.030	5.501	✓			
C	0.200	+/-0.030	0.191	✓			
D	0.25 x 45°	+/-0.030	0.25 x 45°	✓			
E	R0.250	+/-0.030	0.25	✓			
F	0.250	+/-0.010	0.248	✓			
G	0.625	+/-0.030	0.623	✓			
H	0.375	+/-0.010	0.378	✓			
I	0.950	+0.030/0.010	0.946	✓			
J	19.000	+/-0.030	19.00	✓		Tape measure	
K	3.14	+/-0.030	3.14	✓			
L	3.28	+/-0.030	3.272	✓			
M	Ø0.260	+0.005/-0.000	0.260	✓			
N	Ø0.93	+/-0.030	0.928	✓			
O	0.30	+0.030/-0.000	0.318	✓			
P	23.750	+/-0.030	23.750	✓		Tape measure	
Q	7.375	+/-0.030	7.370	✓			
R	4.250	+/-0.010	4.254	✓			
S	2.000	+/-0.030	2.005	✓			
T	9.000	+/-0.010	9.008	✓			
U	9.000	+/-0.010	9.008	✓			
V	0.375	+/-0.010	0.385	✓			

Measured by: <i>EP</i>	Audited by: <i>JM</i>	Prototype Approval:	N/A
Date: 05/04/12	Date: 05/04/13	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 14, 2005
08:26 am

Work Order No : 0022688
Project Name : K10008
Project For : WK512
Work Order Type : Main
Main WO Number :
House Part Number : *K10008

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Bearpaw kit 19" x 24"
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0

Order Entry No :
OE Value : 0.00

Start Date : 03-11-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

OK for Approval :
Approval Rec'd :

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
OK	=====	=====	=====		
Burden :	0.00	0.00	0.00		
	=====	=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00